shp Aug 30

Work Order ID 73060

Thursday, August 25, 2011 6:58:09 AM

Item ID: D2330-043 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Basket Lid Assembly

Start Date: 8/25/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 8/31/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:** **Run Start**

QC: **Date:** **SPC (Y/N):** **Date:** **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D2330	**Revision Nbr** Rev H								
100	Large Fab	0.00							
Large Fab									
Large Fab	**Memo**	0.00							
Large Fab	1- Cut D2330-1-3-9 as per Dwg D2330 2-Drill hole in D2330-3 as per Dwg D2330 3-Deburr								
110	Large Fab	0.00							
Large Fab									
Large Fab	**Memo**	0.00							
Large Fab	1-Weld as per Dwg D2330 using Welding Table and corner Jig Deburr as required A/R SS ROD Batch: 117884								
120	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC									
Quality Control	**Memo**	0.00							

11.08.30

11.08.30

BE 11.08.30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 73060

Thursday, August 25, 2011 6:58:09 AM

Item ID: D2330-043 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Basket Lid Assembly

Start Date: 8/25/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 8/31/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:** **Run Start**

QC: **Date:** **SPC (Y/N):** **Date:** **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									
135	Pressure Wash per QSI005 4.3	0.00							
HandFinish	**Memo**	0.00							
Hand Finishing									
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: 7:30 OVEN TEMPERATURE: 400°F FINISH TIME: 8:00								

8/30

1X Ø M-F 11/08/30

1X Ø M-F 11/08/31

MM745

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 73060

Thursday, August 25, 2011 6:58:09 AM

Item ID: D2330-043 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Basket Lid Assembly

Start Date: 8/25/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 8/31/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00				1		BR 11-8-31	
QC	**Memo**	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: 6-A w/o 73058	0.00							
Packaging	**Memo**	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

11/08/31

11/8/31

MK 11-08-31

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Thursday, August 25, 2011 6:58:06 AM

Work Order ID: 73060

Parent Item: D2330-043

Parent Item Name: Basket Lid Assembly

Start Date: 8/25/2011 **Required Date:** 8/31/2011

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev:H 02.09.04 M304EX0.75-16F was M750-16FXS-S/S KJ
IPP Rev:I 08-09-09 revF as per dwg (ecn 08-522) DD verf:EC
IPP REV:J 10.11.30 AS PER DWG REV.H DD VERF:EC

Component Item ID / Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2252-1 Frame		Manufactured	No			100	Each	12.0000	2	2		11.08.25	

Location	Loc Qty	Loc Code
WA006	12	
51941	4	
58084	8	

D2252-7 Frame		Manufactured	No			100	Each	4.0000	4	4		11.08.25	

Location	Loc Qty	Loc Code
WA	4	
70970	4	

D2327-3 Spacer Bushing		Manufactured	No			100	Each	22.0000	1	1		11.08.25	

Location	Loc Qty	Loc Code
WA	22	
71971	3	
72296	19	

D2329 Label Plate		Manufactured	No			100	Each	4.0000	1	1		11.08.29	

Location	Loc Qty	Loc Code
WA006	4	
40488	4	

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Thursday, August 25, 2011 6:58:06 AM

Work Order ID: 73060

Parent Item: D2330-043

Parent Item Name: Basket Lid Assembly

Start Date: 8/25/2011 **Required Date:** 8/31/2011

Start Qty: 1.00 **Required Qty:** 1.00

D2330-1 Frame	Manufactured	No	100	Each	0.0000	2	2	B73066 (2) 11.08.25
D2330-15 Frame	Manufactured	No	100	Each	2.0000	1	1	

Location	Loc Qty	Loc Code
WA	2	
59262	1	
70835	1	

11.08.25 (1)

D2581 Mounting Bracket	Manufactured	No	100	Each	33.0000	2	2	11.08.25

Location	Loc Qty	Loc Code
WA	33	
69258	26	
69739	2	
70766	5	

(2)

D3749-1 Hinge Half	Manufactured	No	100	Each	15.0000	3	3	11.08.29

Location	Loc Qty	Loc Code
WA	15	
70063	15	

(3)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Thursday, August 25, 2011 6:58:07 AM

Work Order ID: 73060

Parent Item: D2330-043

Parent Item Name: Basket Lid Assembly

Start Date: 8/25/2011 **Required Date:** 8/31/2011

Start Qty: 1.00 **Required Qty:** 1.00

M304EX0.75-16F	Purchased	No	100	sf	918.8851	18.9	18.9	GL 11-08.30

Expanded Metal Flat SS

Location	Loc Qty	Loc Code	
WA	918.885055		
115012	95		
117197	102.9036		
117455	16.0341		
117896	53.3264		
118153	98.6394		
118248	33.0983		
118450	199.883255		
118597	320		18.9

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2330-041	BASKET ASSEMBLY
3		X	D2330-043	LID ASSEMBLY
7	1		D2012-107	CLEVIS
8	4		D2235-1	RIB
9	2	2	D2252-1	FRAME
10	1	4	D2252-7	FRAME
11	2		D2253-1	LUG
12	2		D2254	GUSSET
13	1	1	D2327-3	BUSHING
14		1	D2329	LABEL PLATE
15	2	2	D2330-1	FRAME
16	1		D2330-5	FRAME
17	1		D2330-7	FRAME
18		1	D2330-15	FRAME
19	4	2	D2581	MOUNTING CHANNEL
20	3		D3748-1	HINGE HALF
21		3	D3749-1	HINGE HALF

RELEASED
2010 -11- 25

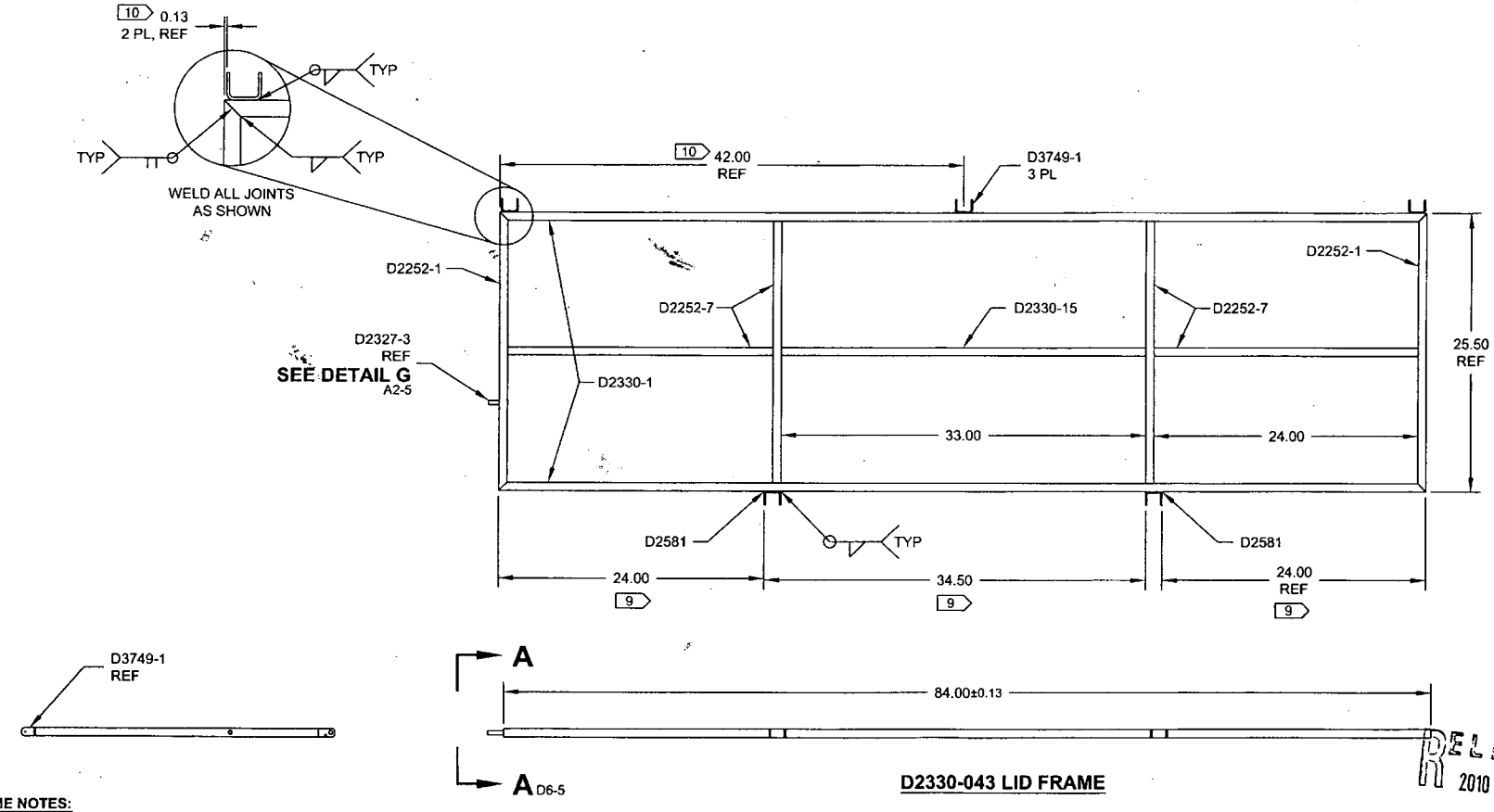
REV.	DESCRIPTION	BY	DATE
H	DIM 0.50 WAS 0.75 (ZN D2-3 & D6-3) REF NCR 10-346	JPH	10.09.28
G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 20 AND 21 REPLACE D2232-1/-3; STRETCHED LID FROM 83.27" TO 84.00"; ITEMS 9 &10 REPLACE D2330-3/-9/-13; ITEM 13 (ON LID) REPLACES D2327-1; REORGANIZED ALL SECTION & DETAIL VIEWS. REASON: SEE PAR#09-006.	MB	09.02.05
F	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 6 ADDED. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1. D2253-1 WAS D2253 (NCR 533).	KE	05.11.10
D	MODIFIED LATCH, REDRAWN	KE	99.09.14
C	ADDED LATCH AND LABEL PLATE	BK	96.05.23

w/o 73060

NOTES:
1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A
8) WEIGHT: N/A
9) WELDING: PER DART QSI 004

DESIGN	JB	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. REV. H
MFG. APPR.		D2330 SHEET 1 OF 6
APPROVED		TITLE SCALE
DE APPR.		BASKET ASSEMBLY (206B) NTS
DATE	10.09.28	

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D2330-043 LID FRAME

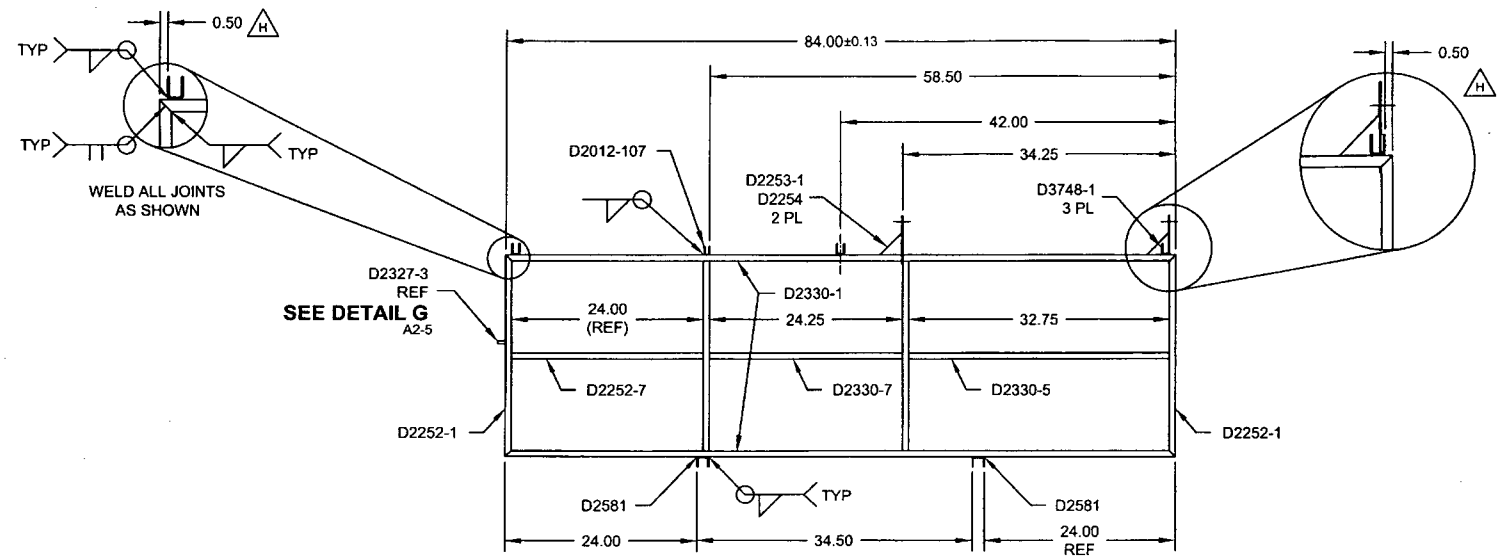
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2010-11-25

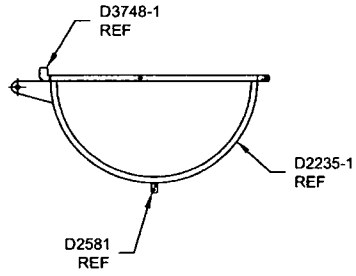
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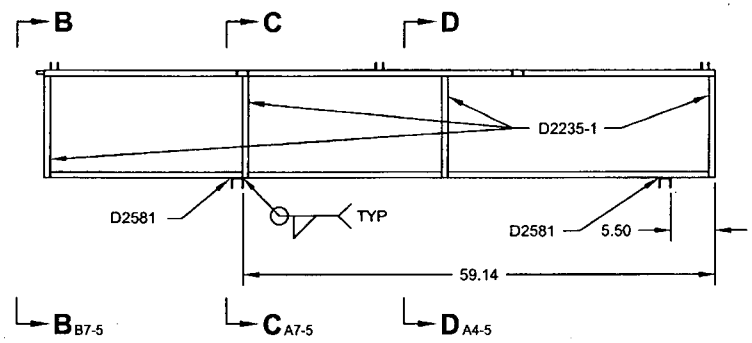
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2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A
8) WELDING: PER DART QSI 004
9) ALIGN WITH ADJACENT D2581 ON BASE
10) CENTER D3749-1 HINGE HALF ON D3748-1 HINGE HALF LOCATED ON D2330-041 BASKET BASE ASSEMBLY

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2330	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206B)	NTS
DATE	10.09.28		

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2010-11-25

D2330-041 BASE FRAME ASSEMBLY

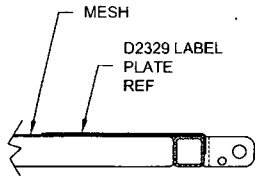
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1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A
8) WELDING: PER DART QSI 004

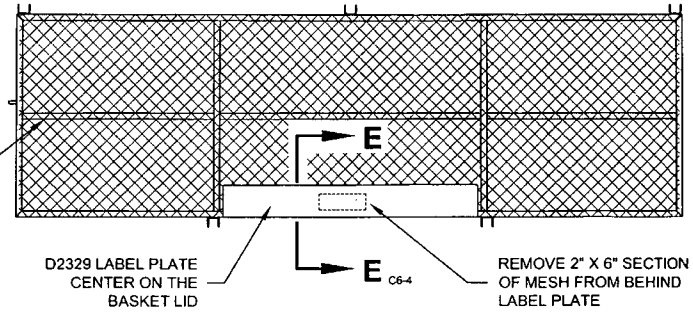
73060

DESIGN	JB	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	For JPH	
CHECKED		DRAWING NO. D2330 — REV. H — SHEET 3 OF 6
MFG. APPR.		
APPROVED		TITLE: BASKET ASSEMBLY (206B) — SCALE: NTS
DE APPR.		
DATE	10.09.28	

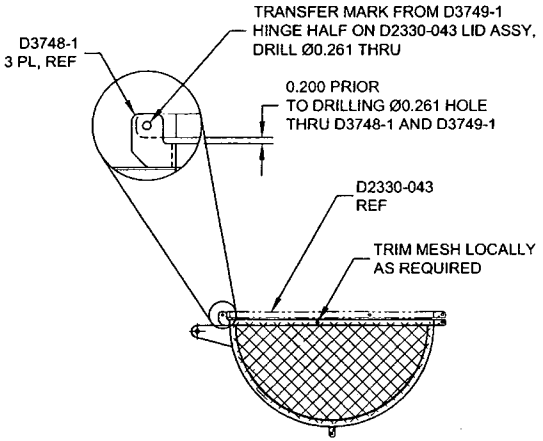
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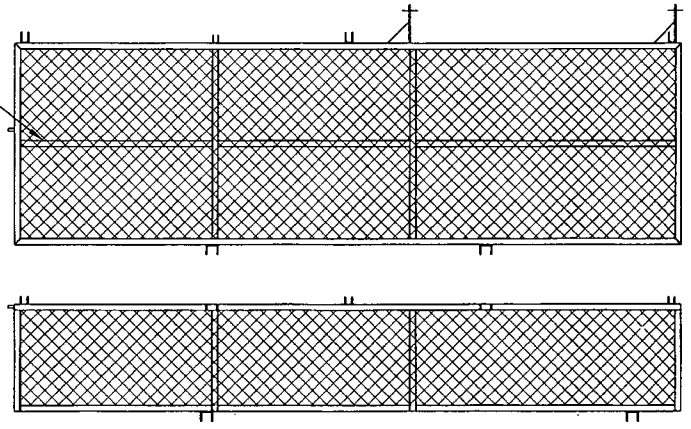


SECTION E-E C3-4
VIEW ROTATED 90° CCW



D2330-043 LID ASSEMBLY





D2330-041 BASE ASSEMBLY

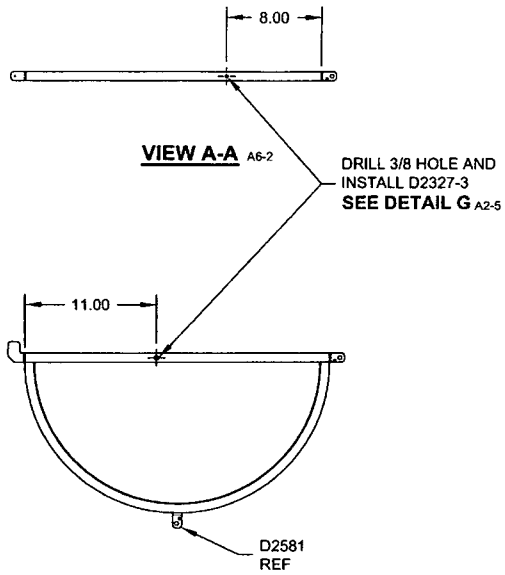
RELEASED
2010 -11- 25

ASSEMBLY NOTES:
1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A
8) WELDING: PER DART QSI 004

73060

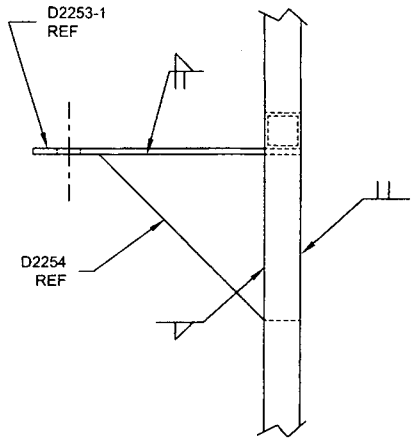
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DRAWN		DRAWING NO.	REV. H
CHECKED		D2330	SHEET 4 OF 6
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET ASSEMBLY (206B)	NTS
DE APPR.			
DATE	10.09.28		

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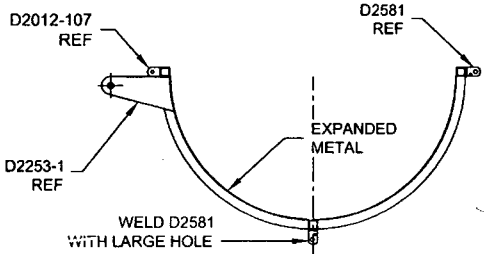


VIEW A-A A6-2

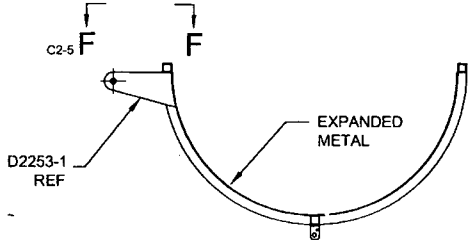
VIEW B-B A5-3



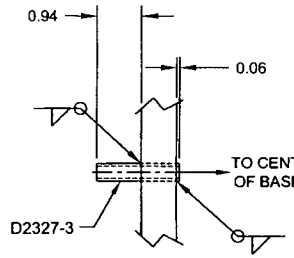
VIEW F-F B6-5
SCALE 4X



SECTION C-C A4-3



SECTION D-D A3-3



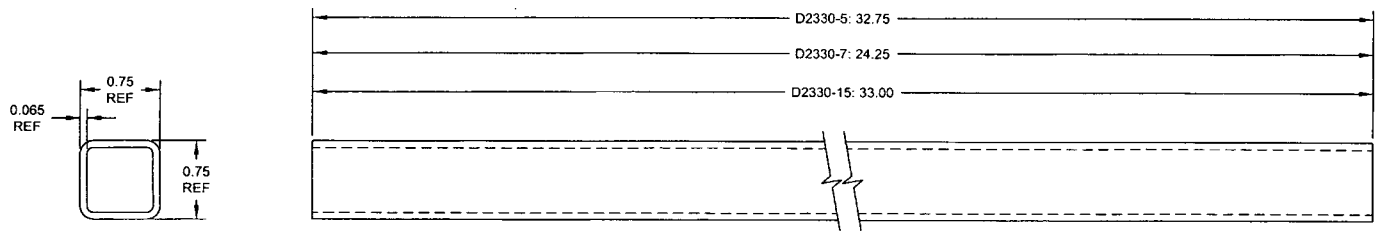
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2010-11-25

DETAIL G C6-2
SPACER INSTALLATION C5-3 C6-5
SCALE 4X

93060

DESIGN	JB	**DART AEROSPACE LTD**	
DRAWN	FOR JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2330	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206B)	NTS
DATE	10.09.28		

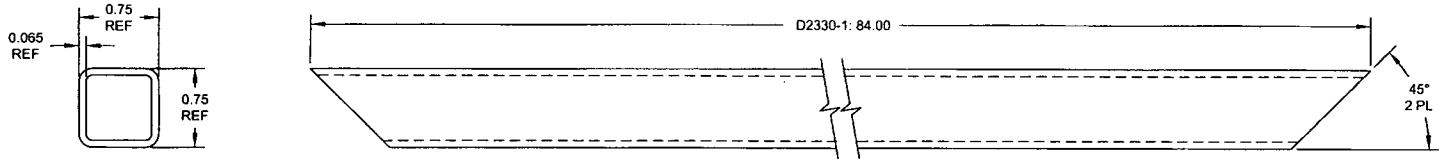
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D2330-5 FRAME

D2330-7 FRAME

D2330-15 FRAME



D2330-1 FRAME

RELEASED
2010-11-25

NOTES:
1) FRAME MATERIAL: SEE SHEET 1
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

13060

DESIGN	JB	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. H
CHECKED		D2330	SHEET 6 OF 6
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET ASSEMBLY (206B)	NTS
DE APPR.			
DATE	10.09.28		

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